



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.4001

Job Sheet 175984



Part No: 646.4001

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/13/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 5/22/18

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	1 Ea		5/22/18	0.00	0.00	Start Up Stores/Pkg-1		APR 28 2018
110	Packaging	1 pcs		5/22/18	0.00	0.00	Packaging1-1		APR 27 2018
120	QC	1 pcs		5/22/18	0.00	0.00	QC4		
125	DC	1 pcs		5/22/18	0.00	0.00	DC		
130	Packaging	1 pcs		5/22/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		5/22/18	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile & type labels per PPP 646.4001

Descriptions: 130 - Identify and pack for shipping as per PPP 646.4001 Location: F9102

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	
646.3210	Support	1 Ea (1 ea)	90-Start up Operation	
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	
646.3710	Doubler	1 Ea (1 ea)	90-Start up Operation	
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	
646.3713	Gusset	1 Ea (1 ea)	90-Start up Operation	
646.3714	Gusset	1 Ea (1 ea)	90-Start up Operation	
646.3715	Strut Doubler	2 Ea (2 ea)	90-Start up Operation	
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	
646.3717	Doubler	1 Ea (1 ea)	90-Start up Operation	

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Container No: S064753



Part: 646.4001

Job No: 175984

Serial No/Batch: S064753

Revision:

Inspector:

Date: 04/24/18

646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation
646.3719	Doubler	2 Ea (2 ea)	90-Start up Operation
646.3810	Bracket	2 Ea (2 ea)	90-Start up Operation
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation
646.3812	Gusset Bracket	2 Ea (2 ea)	90-Start up Operation
646.3813	AS350 Strut Bracket	1 Ea (1 ea)	90-Start up Operation
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation
647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation
AN3-3A	Bolt	4 Ea (4 ea)	90-Start up Operation
AN3-4A	Bolt	10 Ea (10 ea)	90-Start up Operation
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	90-Start up Operation
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	90-Start up Operation
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	90-Start up Operation
MS20470AD5-6	Rivet	8 Ea (8 ea)	90-Start up Operation
MS20470AD5-7	Rivet	3 Ea (3 ea)	90-Start up Operation
MS21042L3	Nut	63 Ea (63 ea)	90-Start up Operation
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation
MS21042L8	Nut	2 Ea (2 ea)	90-Start up Operation
MS21047-3	Nut Plate	18 Ea (18 ea)	90-Start up Operation
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation
MS27039-1-10	Screw	2 Ea (2 ea)	90-Start up Operation
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation
NAS1149F0332P	Washer	144 Ea (144 ea)	90-Start up Operation
NAS1149F0363P	Washer	2 Ea (2 ea)	90-Start up Operation
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	448	0
	600.0990	1	22	0
	600.0991	1	21	0
	600.1012	1	25	0
	600.1013	5	30	0
	646.2910	1	9	0
	646.3001	1	7	0
	646.3110	1	21	0
	646.3210	1	7	0
	646.3301	1	6	0

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

646.3510	1	26	0
646.3511	1	15	0
646.3610	1	19	0
646.3710	1	73	0
646.3711	1	29	0
646.3712	1	41	0
646.3713	1	34	0
646.3714	1	40	0
646.3715	2	48	0
646.3716	1	27	0
646.3717	1	31	0
646.3718	2	52	0
646.3719	2	22	0
646.3810	2	21	0
646.3811	1	28	0
646.3812	2	16	0
646.3813	1	18	0
646.3910	4	41	0
646.3911	1	42	0
646.3912	4	30	0
646.3913	1	58	0
646.9410	1	121	0
647.0112	2	86	0
647.7703	2	16	0
650.9201	2	20	0
AN3-11A	10	235	0
AN3-12A	2	103	0
AN3-13A	1	55	0
AN3-3A	4	796	0
AN3-4A	10	504	0
AN3-5A	2	396	0
AN3-6A	2	255	0
AN316C4R	2	44	0
AN44-5A	2	21	0
AN4C7A	2	89	0
AN665-34R	2	38	0
CCR264SS3-02	36	482	0
CR3213-5-3	14	180	0
MS20426AD5-7	2	1,201	0
MS20470AD5-5.5	8	373	0
MS20470AD5-6	8	1,167	0
MS20470AD5-7	3	197	0
MS21042L3	63	2,448	0
MS21042L4	2	3,323	0
MS21042L8	2	0	0
MS21047-3	18	406	0
MS24693-C278	5	60	0
MS24694-S51	5	264	0
MS24694-S54	2	115	0
MS24694-S55	3	170	0
MS27039-08-13	2	415	0
MS27039-1-10	2	301	0
MS27039-1-12	6	343	0
MS27039-1-16	24	588	0
MS27039-1-19	22	261	0
MS27039-1-20	2	69	0
MS27039-1-21	4	102	0
NAS1149F0332P	144	3,125	0
NAS1149F0363P	2	239	0
NAS1149F0432P	4	2,245	0
NAS1149FN832P	4	3,306	0

Part Specifications

Specifications could not be found.

Plex 4/13/18 8:33 AM Dart.Gagnon.Michelle



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002688	S064399	600.0129	VHB Tape	s031229	CCK096	8
002688	S064398	600.0990	Magnabond 6398 Part A Size 112 ml	s044948	LG050	1
002688	S064397	600.0991	Magnabond 6398 Part B Size 112 ml	s044949	LG050	1
002688	S064396	600.1012	Sealant PR1425B2 (#654 sem)	s054101	CCK017	1
002688	S064395	600.1013	021200-3M Tape Primer 94 Primer 24216	S020598	CCK096	5
002688	S064394	646.3001	Lower Cable Cutter Assembly	s056954	CCK023	1
002688	S064393	646.3110	Channel	s059069	CCK020	1
002688	S064392	646.3210	Support	s045159	CCK020	1
002688	S064391	646.3510	Strut	s036174	CCK103	1
002688	S064390	646.3511	Strut	s050455	CCK108A	1
002688	S064389	646.3610	Filler	s021581	CCK104	1
002688	S064388	646.3710	Doubler	s002104	CCK006	1
002688	S064387	646.3711	Clip	s038799	CCK104	1
002688	S064386	646.3712	Clip	s026726	CCK104	1
002688	S064385	646.3713	Gusset	s026788	CCK104	1
002688	S064384	646.3714	Gusset	s026731	CCK104	1
002688	S064383	646.3715	Strut Doubler	s050316	CCK105	2
002688	S064382	646.3716	Gauge Bracket	s027170	CCK105	1
002688	S064381	646.3717	Doubler	s050430	CCK105	1
002688	S064380	646.3718	Custom Washer	s050515	CCK105	2
002688	S064379	646.3719	Doubler	s050441	CCK105	2
002688	S064378	646.3810	Bracket	s058167	CCK105	2
002688	S064377	646.3811	Radius Block	s057868	CCK105	1
002688	S064376	646.3812	Gusset Bracket	s058076	CCK105	2
002688	S064375	646.3813	AS350 Strut Bracket	s057988	CCK105	1
002688	S064374	646.3910	Shim	s051515	CCK105	4
002688	S064372	646.3911	Shim	s051519	CCK105	1
002688	S064371	646.3912	Shim	s051511	CCK105	4
002688	S064369	646.3913	Shim	s051513	CCK105	1
002688	S064368	646.9410	Shim	f140671	CCK011	1
002688	S064367	647.0112	Strut Bracket	s054605	CCK106	2
002688	S050812	647.7703	Strut Assembly	F160715	CCK114	2
002688	S063545	AN3-11A	Bolt	S027721	ST349	10
002688	S063544	AN3-12A	Bolt	S048376	ST349	2
002688	S063543	AN3-13A	Bolt	S038733	ST349	1
002688	S064362	AN3-3A	Bolt	S015688	ST350	4
002688	S063542	AN3-4A	Bolt	S019388	ST350	10
002688	S063541	AN3-5A	Bolt	S041106	ST350	2
002688	S063540	AN3-6A	Bolt	S000530	ST350	2
002688	S063539	AN316C4R	Nut, Jam	S019359	ST331	2
002688	S063538	AN44-5A	Eyebolt	S041156	ST339	2
002688	S063537	AN4C7A	Bolt	S027516	ST345	2
002688	S063536	AN665-34R	Clevis	S041157	ST330	2
002688	S063535	CCR264SS3-02	Cherry Rivet	S041159	ST321	36
002688	S063534	CR3213-5-3	Cherry Rivet	S019378	ST319	14
002688	S063533	MS20426AD5-7	Rivet	F153848	ST311	2
002688	S063532	MS20470AD5-5.5	Rivet	FM134063	ST309	8
002688	S063531	MS20470AD5-6	Rivet	F124089	ST309	8
002688	S063530	MS20470AD5-7	Rivet	F123425	ST309	3

11/18

208/2018

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002688	S063529	MS21042L08	Nut	S044234	ST303	2
002688	S063528	MS21042L3	Nut	S038764	ST303	63
002688	S063527	MS21042L4	Nut	S045901	ST303	2
002688	S063526	MS21047-3	Nut Plate	S020620	ST301	18
002688	S063525	MS24693-C278	Screw	S016502	ST287	5
002688	S063524	MS24694-S51	Screw	S004859	ST284	5
002688	S063523	MS24694-S54	Screw	S024480	ST284	2
002688	S063522	MS24694-S55	Screw	FM138621.0	ST283	3
002688	S063521	MS27039-08-13	Screw	S019320-1	ST278	2
002688	S063520	MS27039-1-10	Screw	S005145	ST280	2
002688	S063519	MS27039-1-12	Screw	S049832	ST280	6
002688	S063518	MS27039-1-16	Screw	S049833	OVER006	24
002688	S063517	MS27039-1-19	Screw	S050051	ST280	22
002688	S063516	MS27039-1-20	Screw	S000680	ST280	2
002688	S063515	MS27039-1-21	Screw	S037684	ST280	4
002688	S063514	NAS1149F0332P	Washer	S057525	ST262	144
002688	S063513	NAS1149F0363P	Washer	S027738	ST262	2
002688	S063512	NAS1149F0432P	Washer	S050055	ST262	4
002688	S063511	NAS1149FN832P	Washer	S020604	ST263	4

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/24/18 9:05 AM dart.quirion.sonia

pk
 650 9201 S059378 nut x2
 646 2910 S058968
 646 3301 S060222

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NOTES:

▲ AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

A  3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N Q21200-24216.

△ REUSE FASTENERS FROM F/N 1.

 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(s)

0.5304

	5		5		5	78	601.3875	SCREW	HSTCNC3A	
1			1		1	77	646.9410	SHIM		
			4		4	76	601.2764	WASHER	NAST18PMBZP	
			2		2	75	601.2973	LOCKNUT	MS21042-0R	
			2		2	74	601.2988	SCREW	MS27039-0B13	
			2		2	73	601.2943	LOCKNUT	MS21042-S	
			2		2	72	601.3128	NUT	ANS16CAR	
			2		2	71	601.3209	LOCKNUT	MS21042-L	
			4		4	70	601.2638	WASHER	NAST18PMDZP	
			2		2	69	601.2669	BOLT	ANAC7A	
			2		2	68	601.3119	CLEVIS	ANM65-3AR	
			2		2	67	601.3121	EYE BOLT	AY446-SA	
			2		2	66	650.9201	EYE BRACKET ASSY		
REF		REF		REF		65	647.5701	GPS MOUNT KIT		
				2		64	601.3151	WASHER	NAST14PPG3K3P	
						63	601.2911	SCREW	MS2464Y453	
			24		24	62	601.2637	SCREW	MS27039-1-1A	
2			2		2	61	601.2763	BOLT	ANS-12A	
			1		1	60	646.3913	SHIM	X	
			4		4	59	646.3912	SHIM		
			1		1	58	646.3911	SHIM		
			4		4	57	646.3910	SHIM		
			5		5	56	600.1013	PRIMER		
			8 FT		8 FT	55	600.0129	VHB TAPE		
			1		1	54	600.1012	SEALANT	PR-11CS CLASS B	
					1	53	600.0991	MAGNOBOND 6398 PART B		
					1	52	600.0990	MAGNOBOND 6398 PART A		
6			10		10	51	601.2826	BOLT	ANS-11A	
					2	50	646.3814	WIPER BRACKET		
					2	49	601.2910	SCREW	MS27039-1-1B	
			2		2	48	601.1365	SCREW	MS27039-1-1D	
			2		2	47	646.3719	DOUBLER		
			2		2	46	646.3718	CUSTOM WASHER		
			1		1	45	646.3717	DOUBLER		
			22		22	44	601.1946	SCREW	MS27039-1-19	
			2		2	43	601.1952	SCREW	MS27039-1-20	
					4	42	601.1956	SCREW	MS27039-1-21	
AOC6	AOC3	AOC4	AOC3	AOC2	AOC1	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

[illegible]